

Wednesday, 5/16/2007 8:13:41 AM
Kim Johnston

Process Sheet

23

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	206/OH-58 SADDLE, INBOARD, RIGHT SIDE		
Job Number	32380	Part Number	D29332		
Estimate Number	10834	Drawing Number	D2933 REV C		
P.O. Number	N/A	Project Number	N/A		
This Issue	5/16/2007	S.O. No.	N/A		
Prsh Rev.	NC	Drawing Revision	C		
First Issue	N/A	Material	N/A		
Previous Run	31251	Due Date	6/6/2007		
Written By	<u>Off 07-05-16</u>				
Checked & Approved By					
Comment	Est: B 00-06-26 New DWG rev (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	D6101001	7075-T7351 2X6X6.25	
		Comment: Qty.: 1.0000 Each(s)/Unit Total: 16.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: B25345	J.L 07/05/27
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 5-Deburr	J.F. J.L 07/05/28
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	er 07/06/07
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	J.F. 07/06/07

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 32380

Part Number: D29332

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK

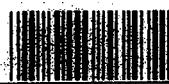


Comment: SECOND CHECK

SMK 07/06/09 (10)

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

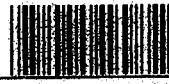
4.1 07-06-10 16

7.0 SPRAY PAINTING

SPRAY PAINTING



P/I: 4058 (07/06/27) 2



Comment: SPRAY PAINTING

PR

-PRIME

-PAINT DELFLEET BLUE

8.0 QC14

INSPECT SPRAY PAINT



07-07-03 2



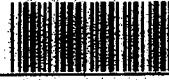
Comment: INSPECT SPRAY PAINT

9.0 PACKAGING 1

PACKAGING RESOURCE #1



07-07-03 2



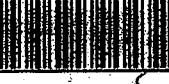
Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

6/1/04 2

10.0 QC21

FINAL INSPECTION/W/O RELEASE



2

Comment: FINAL INSPECTION/W/O RELEASE

07/07/04

Job Completion



W.D.P. 07/04

DART AEROSPACE LTD	Work Order:	32380
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.119	.119	.119	.119		
B	0.100	0.140		.119	.120	.120	.119		
C	0.100	0.140		.124	.120	.120	.119		
D	0.210	0.230		.222	.221	.221	.221		
E	1.245	1.255		1.256	1.250	1.256	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.511	.511	.511	.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.499	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.120	.120	.119	.119		
O	0.540	0.560		.549	.550	.550	.550		
P	0.490	0.510		.501	.500	.500	.501		
Q	3.715	3.725		3.719	3.719	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.252	.251	.250	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.636		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.125	1.145		1.137	1.137	1.136	1.137		
Y	1.565	1.585	DT8695 A/B	1.576	1.576	1.576	1.576		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	JL	En	Audited by:	Onk
Date:	07/05/07	07/06/07	Date:	07/06/07

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	JLM

DART AEROSPACE LTD

Work Order: 32380

Description: 206 Saddle, Inboard, Right side

Part Number: D2933-2

Inspection Dwg: D2933 Rev. C

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.121	.122	.121	.120		
B	0.100	0.140		.120	.120	.120	.119		
C	0.100	0.140		.121	.119	.120	.120		
D	0.210	0.230		.221	.221	.221	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.515	0.514	0.514	0.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		.119	.119	.119	.120		
O	0.540	0.560		.549	.549	.550	.550		
P	0.490	0.510		.501	.499	.501	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.490	2.490	2.490	2.490		
S	0.240	0.270		.250	.251	.251	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.629	1.620		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.125	1.145		1.136	1.135	1.137	1.140		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.576	1.578		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by: J. FCR
Date: 07/05/08 / 07/06/09Audited by: GML
Date: 07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	SPJ

DART AEROSPACE LTD	Work Order:	32380
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.120	.120	.120	.120"		
B	0.100	0.140		.120	.120	.120	.126"		
C	0.100	0.140		.121	.121	.119	.125"		
D	0.210	0.230		.221	.220	.219	.224"		
E	1.245	1.255		1.255	1.256	1.250	1.250"		
F	1.245	1.255		1.250	1.250	1.250	1.250"		
G	2.495	2.505		2.500	2.500	2.500	2.500"		
H	0.510	0.515		0.511	0.511	0.511	0.511"		
I	1.572	1.582		1.577	1.577	1.577	1.577"		
J	2.495	2.505		2.500	2.500	2.500	2.500"		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.315	.315	.315	.315		
M	0.235	0.240		0.239	0.239	0.239	0.239"		
N	0.100	0.140		.120	.120	.119	.119"		
O	0.540	0.560		.548	.550	.550	.550"		
P	0.490	0.510		.501	.502	.502	.504"		
Q	3.715	3.725		3.720	3.720	3.717	3.720"		
R	2.470	2.510		2.490	2.490	2.490	2.490"		
S	0.240	0.270		.252	.250	.252	.256"		
T	0.100	0.180		.140	.140	.140	.140"		
U	1.625	1.635		1.630	1.630	1.630	1.630"		
V	1.362	1.372		1.367	1.367	1.367	1.367"		
W	0.316	0.321		.320	.320	.320	.320		
X	1.125	1.145		1.135	1.135	1.135	1.135		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by:	JL / J.F. /	Audited by:	OMR
Date:	07/06/09	Date:	07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	SD

DART AEROSPACE LTD	Work Order:	32380
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date	
A	0.100	0.140		.117"	.120"	.121"	.119"			
B	0.100	0.140		.117"	.122"	.122"	.121"			
C	0.100	0.140		.125"	.125"	.125"	.125"			
D	0.210	0.230		.224"	.225"	.223"	.225"			
E	1.245	1.255		1.250"	1.250"	1.250"	1.250"			
F	1.245	1.255		1.250"	1.250"	1.250"	1.250"			
G	2.495	2.505		2.500"	2.500"	2.500"	2.500"			
H	0.510	0.515		0.511"	0.511"	0.511"	0.511"			
I	1.572	1.582		1.579"	1.579"	1.579"	1.579"			
J	2.495	2.505		2.500"	2.500"	2.500"	2.500"			
K	0.257	0.262		0.259"	0.259"	0.259"	0.259"			
L	0.312	0.317		0.313"	0.313"	0.313"	0.313"			
M	0.235	0.240		0.239"	0.239"	0.239"	0.239"			
N	0.100	0.140		.120"	.118"	.119"	.121"			
O	0.540	0.560		.552"	.550"	.557"	.550"			
P	0.490	0.510		.504"	.505"	.504"	.505"			
Q	3.715	3.725		3.720"	3.720"	3.720"	3.720"			
R	2.470	2.510		2.490"	2.490"	2.490"	2.490"			
S	0.240	0.270		.256"	.256"	.256"	.255"			
T	0.100	0.180		.140"	.140"	.140"	.140"			
U	1.625	1.635		1.630"	1.630"	1.630"	1.630"			
V	1.362	1.372		1.370"	1.370"	1.370"	1.370"			
W	0.316	0.321		0.319"	0.319"	0.319"	0.319"			
X	1.125	1.145		1.135"	1.136"	1.132"	1.138"			
Y	1.565	1.585	DT8695 A/B	1.575"	1.575"	1.575"	1.575"			
Z	0.178	0.198		0.188"	0.188"	0.188"	0.188"			
AA										
AB										
AC										
AD										
AE										
AF										
AG										
AH										

Accept/Reject

Measured by:	J. F.	16	Audited by:	CMF
Date:	07/05/29	07/06/09	Date:	07/06/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	JLM